

# Work Order ID 50097

Page 1

July 08, 2009 11:13:02 AM

Item ID: D3145-2      Accept      Setup      Start  
Revision ID: B  
Item Name: Bracket      Stop  
Start Date: 7/10/2009      Start Qty: 10.00      Cust Item ID:  
Required Date: 7/31/2009      Req'd Qty: 10.00      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start  
QC:      Date:      SPC (Y/N):      Date:      Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3145	Rev B								

100      0.00  
BAND SAW  
Bandsaw      Memo      0.00  
Jeaspa Bandsaw      Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

mk 09/07/10

(10)

110      0.00  
HAAS CNC VERTICAL MACHINING #1  
HAAS 1      Memo      0.00  
HAAS CNC vertical machine #1      Machine per Folio FA318 and Dwg D3145 □ Debur and Tumble

DTP 09/07/10

(10)

120      0.00  
QC2- Inspect parts off machine FAI/FAIB  
QC      Memo      0.00  
Quality Control

DTP 09/07/10

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 50097**

Page 2

July 08, 2009 11:13:02 AM

Item ID: D3145-2

Accept

Setup Start

Revision ID: B

Stop

Item Name: Bracket

Start Date: 7/10/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check 0.00

QC Memo 0.00

Quality Control

amt 09/10/20

10 0

140 Chemical Conversion Coat per QSI005 4.1 0.00

HandFinish Memo 0.00

Hand Finishing

uno 09/07/20

X10

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

Powdercoat Memo 0.00

Powder Coating

START TIME: 8:00 □ OVEN TEMPERATURE:

320° □ FINISH TIME:

8:30

BL 0907-23

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 50097**

Page 3

July 08, 2009 11:13:02 AM

Item ID: D3145-2

Accept

Setup Start

Revision ID: B

Stop

Item Name: Bracket

Start Date: 7/10/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish

0.00

&gt; 80267123

(10)

f

QC Memo

0.00

Quality Control

170 Identify as per dwg &amp; Stock Location: 67

0.00

Packaging Memo

0.00

Packaging

P 8/7/27 (10)

180 QC21- Final Inspection - Work Order Release

0.00

QC Memo

0.00

Quality Control

09/07/27 J

u 09.07.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

July 08, 2009 11:13:02 AM

Work Order ID: 50097

Parent Item: D3145-2RevB

Parent Item Name: Bracket

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	30.0000	4.0347			

6061-T6 Bar 2.00 x 2.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

30

110167

2.36

13085

12

17124

15.64

17124

4.0347

*Am 09/07/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50097
<b>Description:</b> BRACKET		<b>Part Number:</b> D3145-2
<b>Inspection Dwg:</b>	<b>Rev:</b>	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	± 0.010	0.245	✓			
Ro.250	± 0.010	0.250	✓			(2PLCS)
0.180	± 0.010	0.1815	✓			
1.250	± 0.010	1.250	✓			
1.960	± 0.010	1.963	✓			
φ.221x0.351	± 0.010 / ± 0.010	0.218x0.341	✓			Slot
28.9°	± 1/2°	28.9°	✓			
0.108	± 0.010	0.110	✓			
Ro.330	± 0.010	0.330	✓			
Ro.188	± 0.010	0.1875	✓			TYP
0.125	± 0.010	0.131	✓			TYP
1.636	± 0.010	1.637	✓			REF
95°	± 1/2°	95°	✓			
0.125	± 0.010	0.125	✓			
0.219	± 0.010	0.210	✓			
Ro.125	± 0.010	0.125	✓			
Ro.387	± 0.010	0.387	✓			
0.766	± 0.010	0.766	✓			REF
0.250	± 0.010	0.252	✓			
1.370	± 0.010	1.370	✓			
0.760	± 0.010	0.760	✓			
4.303	± 0.010	4.303	✓			REF

<b>Measured by:</b> DJP
<b>Date:</b> 09/02/14

<b>Audited by:</b> MJA
<b>Date:</b> 09/07/20

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

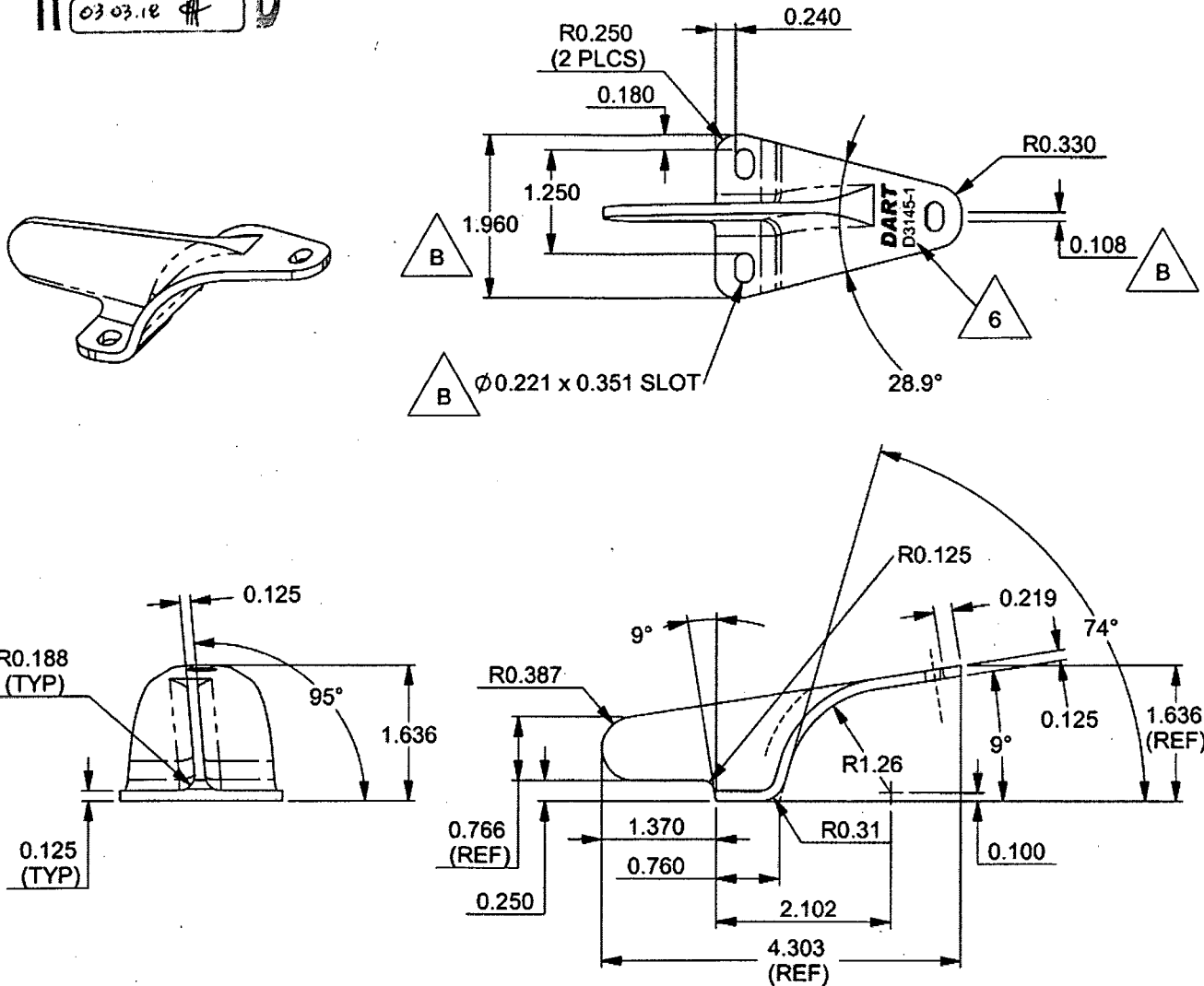
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>TH</i>	DRAWN BY <i>IP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. <b>D3145</b>	REV. B SHEET 1 OF 1
DATE <b>03.02.06</b>		TITLE <b>BRACKET</b>	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

**RELEASED**  
03.03.12



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25  
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

**COPYRIGHT © 2003 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries